

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021973**Date Inspected:** 27-Feb-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Kelly Leavitt, was present during the times noted above for random observations relative to the work being performed.

Bay 10

This QA Inspector observed the following work in progress for Bay 10.

ZPMC was using the Shielded Metal Arc Welding (SMAW) process.

ZPMC QC is identified as Li Ping Fei.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

Heat straightening of PCMK, BK008-001 under approved Heat Straightening procedure, HSR1 (B)-9965. The in process temperature was observed as +250°C. The ZPMC QC was identified as Li Ping Fei. The approved HSR procedure stated that a maximum temperature of 650°C with 1-3 numbers of applications was allowed. The distortion that was previously measured and recorded on the HSR was Maximum 25mm.

Heat straightening of PCMK, BK00X41 under approved Heat Straightening procedure, HSR1 (B)-10109. The in process temperature was observed as +250°C. The ZPMC QC was identified as Li Ping Fei. The approved HSR procedure stated that a maximum temperature of 650°C with 1-3 numbers of applications was allowed. The distortion that was previously measured and recorded on the HSR was Maximum 5mm.

Heat straightening of PCMK, BKX37-001~012 under approved Heat Straightening procedure, HSR1 (B)-10108.

WELDING INSPECTION REPORT

(Continued Page 2 of 4)

The in process temperature was observed as +250°C. The ZPMC QC was identified as Li Ping Fei. The approved HSR procedure stated that a maximum temperature of 650°C with 1-3 numbers of applications was allowed. The distortion that was previously measured and recorded on the HSR was Maximum 3mm.

Components; OBG Bike Path

PCMK: BK015A-001

Weld No: 030

Welder: 051220

WPS-B-P-2112-TC-U5b

Components; OBG Bike Path

PCMK: BK016-001

Weld No: 012

Welder: 040582

WPS-B-P-2112-TC-U5b

Components; OBG Traveler Rail

PCMK: 20TR2-030

Weld No: 009,011,013,015,017,

Welder: 057258, 052493, 052930, 050363, 044511

WPS-B-P-2211-TC-U5b

This QA Inspector observed the following work in progress for Bay 10.

ZPMC was using the Flux Core Arc Welding (FCAW) process.

ZPMC QC is identified as Li Ping Fei.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

Components; OBG Bike Path

PCMK: BK016B-001

Weld No: 017~022

Welder: 050038, 054069

WPS-B-T-2133ESAB

Bay 14

This QA Inspector observed the following work in progress for Bay 14.

ZPMC was using the Flux Core Arc Welding (FCAW) process.

ZPMC QC is identified as Zhan Yuan Yuan, CWI Luli Ging.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

Components; OBG 13E (see photo below)

PCMK: SA3066-001

Weld No: 019,020,024,025

WELDING INSPECTION REPORT

(Continued Page 3 of 4)

Welder: 050242, 055491, 055564, 044795

WPS-B-T-2132-ESAB

This QA Inspector observed the following work in progress for Bay 14.

ZPMC was using the Shielded Metal Arc Welding (SMAW) process.

ZPMC QC is identified as Zhan Yuan Yuan, CWI Luli Ging.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

Components; OBG 13E

PCMK: FB3287-001

Weld No: 008

Welder: 067610

WPS-B-P-2114-FCM-1

This Caltrans QA Inspector observed at random intervals ZPMC performing grinding of welds located on Grillage SA-7152 at various locations due to contour grinding and visual indications as identified by ZPMC QC Inspectors.
(see photo below)

This QA Inspector observed the following work in progress for Bay 14.

ZPMC was using the Shielded Metal Arc Welding (SMAW) process.

ZPMC QC is identified as Li Ping, CWI An Qing Xiang.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

Components; OBG 14W

PCMK: SEG3020AP

Weld No: 002

Welder: 066038

WPS-B-P-2214-B-U2-FCM

This QA Inspector observed the following work in progress for Bay 14.

ZPMC was using the Flux Core Arc Welding (FCAW) process.

ZPMC QC is identified as Li Ping, CWI An Qing Xiang.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

Components; OBG 14 W

PCMK: SEG3020BB

Weld No: 589

Welder: 067949

WPS-B-T-2233-ESAB

Components; OBG 13AW

WELDING INSPECTION REPORT

(Continued Page 4 of 4)

PCMK: SEG3013AH
Weld No: 014
Welder: 066421
WPS-B-T-2233-ESAB

Components; OBG 13AW
PCMK: SEG3013AH
Weld No: 003
Welder: 067876
WPS-B-T-2233-ESAB

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No significant conversations

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact James Devey 1500026784, who represents the Office of Structural Materials for your project.

Inspected By: Leavitt, Kelly

Quality Assurance Inspector

Reviewed By: Riley, Ken

QA Reviewer
